

Date: Friday, 2/23/2007 8:33:17 AM
 User: Kim Johnston

Process Sheet

| | | | |
|-----------------------|---------------------------------------|------------------|--------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : LUG ASSEMBLY |
| Job Number | : 30907 | | |
| Estimate Number | : 11745 | | |
| P.O. Number | : <i>N/A</i> | Part Number | : D3394043 |
| This Issue | : 2/23/2007 | S.O. No. | : <i>N/A</i> |
| Prsht Rev. | : NC | Drawing Number | : D3394 REV A |
| First Issue | : <i>N/A</i> | Project Number | : <i>N/A</i> |
| Previous Run | : 30836 | Drawing Revision | : <i>N/A</i> |
| | | Material | : <i>N/A</i> |
| Written By | : <i>[Signature]</i> | Due Date | : 3/10/2007 |
| Checked & Approved By | : <i>[Signature]</i> | Qty: | <i>66</i> Um: Each |
| Comment | : Est Rev: A New Issue 06-01-06 JLM | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|--------------|
| Seq. #: | Machine Or Operation: | Description: |
|---------|-----------------------|--------------|

| | | |
|-----|-------|---------------|
| 1.0 | D2423 | Lug Extrusion |
|-----|-------|---------------|



Comment: Qty.: 0.0735 f(s)/Unit Total: 4.4100 f(s)
 D2423 Lug Extrusion
 Batch: *B30062*

ml 07/02/05 66

| | | |
|-----|----------|----------|
| 2.0 | BAND SAW | BAND SAW |
|-----|----------|----------|



Comment: BAND SAW
 Cut Blank to .850"

ml 07/03/05 66

| | | |
|-----|-----------------|------------------|
| 3.0 | OUTSIDE SERVICE | OUTSIDE SERVICES |
|-----|-----------------|------------------|



Comment: Sub-Contracting OUTSIDE SERVICES
 Send Blanks To: Metec/Mast Precision Machining
 P/O: *3245*
 Machine D3394-3 as per Dwg D3394

C207/03/06 66

| | | |
|-----|-------------|-----------------------|
| 4.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1
 Receive & Inspect For Transit Damage

[Signature] 04/03/07

| | | |
|-----|-----|-------------------|
| 5.0 | QC6 | DIMENSIONAL CHECK |
|-----|-----|-------------------|



Comment: DIMENSIONAL CHECK

[Signature] 07/03/07

(10)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 2 Date: 07/03/29
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|----------|------|--|-----------------------------|---------------------------------|-----------------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 07/03/29 | 5.0 | Some parts need deburring & the GC need a slight tumble. | <u>2</u> QSI042 | debur as necessary i: tumble | <u>SB</u> 07/03/28 | <u>2</u> 07/03/28 | <u>2</u> QSI042 | <u>2</u> 07/03/29 |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY

Job Number: 30907

Part Number: D3394043

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



66x

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-H

07/03/28

7.0

POWDER COATING

POWDER COATING



M/03/41

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FR

07/03/28 66

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SRB 07/03/28 66

9.0

MS3548993

GROMMET



Comment: Qty.: 2.0000 Each(s)/Unit Total: 120.0000 Each(s)

Pick:

M102982

17

Qty Part Number Description Batch

M103381

15

2 MS35489-93 Grommet

M103691

100

SRB 07/03/28 66

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3394

SRB 07/03/28 66

11.0

QC5

INSPECT WORK TO CURRENT STEP



07/03/28

Comment: INSPECT WORK TO CURRENT STEP

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

07/03/29 66

13.0

QC21

FINAL INSPECTION/W/O RELEASE



66

Comment: FINAL INSPECTION/W/O RELEASE

07/03/29

Job Completion



07/03/30

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

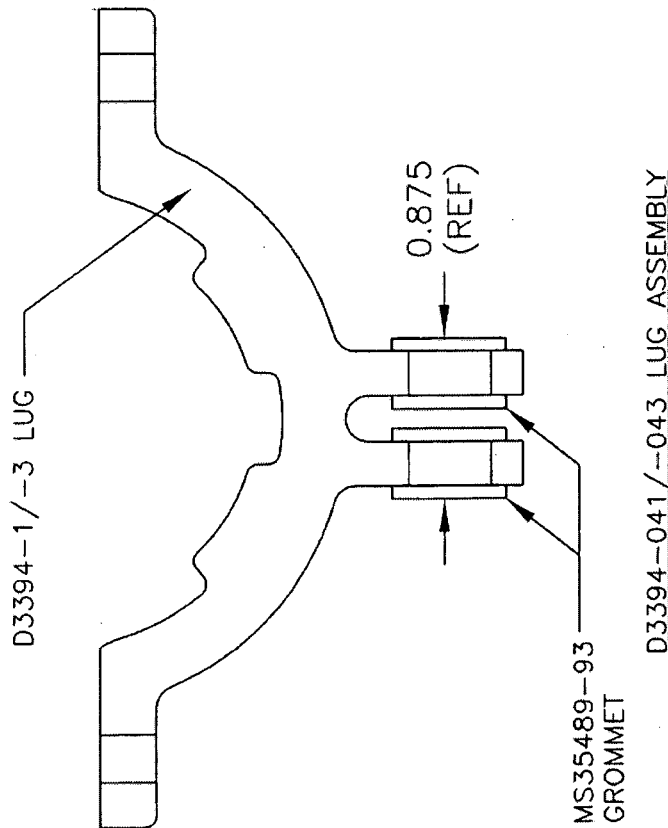
QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



| | | | |
|------------------------|-------------------------|---|------------------------|
| DESIGN PH | DRAWN BY PH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED [Signature] | APPROVED [Signature] | DRAWING NO. D3394 | REV. A SHEET 1 OF 3 |
| DATE 05.02.14 | | TITLE LUG | SCALE 1:1 |
| A | 05.02.14 | NEW ISSUE | |



PARTS LIST FOR D3394-041/-043 LUG ASSEMBLY

| QTY - | | QTY - | QTY - | PART NUMBER | DESCRIPTION |
|-------|---|-------|-------|-------------|--------------|
| 041 | X | 043 | | D3394-041 | LUG ASSEMBLY |
| | | | X | D3394-043 | LUG ASSEMBLY |
| 1 | | | | D3394-1 | LUG |
| | | 1 | | D3394-3 | LUG |
| 2 | | 2 | | MS35489-93 | GROMMET |

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WITHOUT NOTICE
WORK ORDER
NO. 30907

RELEASED

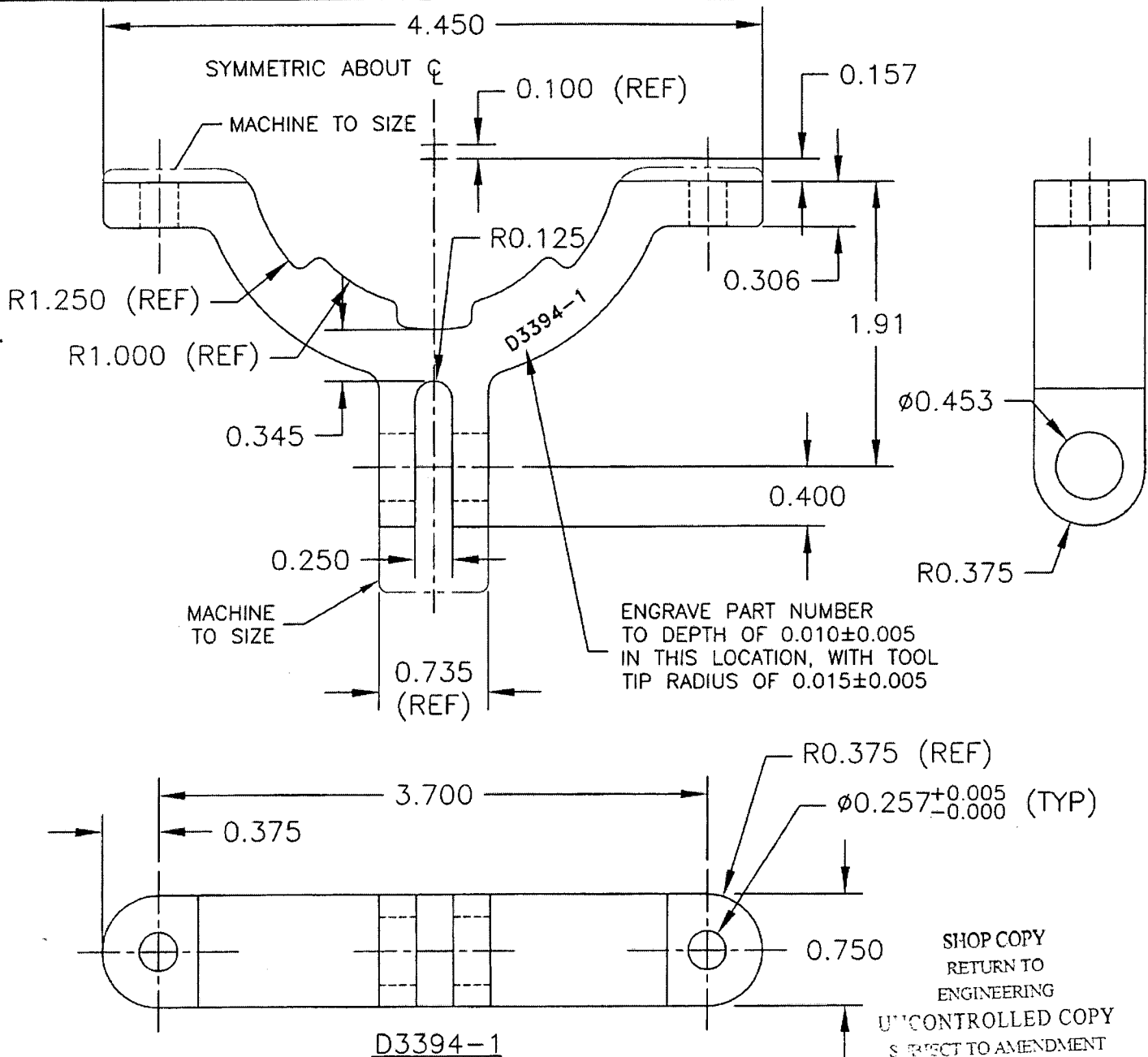
05.11.14

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| CHECKED PH | APPROVED PH | DRAWING NO. D3394 | REV. A SHEET 2 OF 3 |
| DATE 05.02.14 | TITLE LUG | | SCALE 1:1 |

**D3394-1 NOTES**

- 1) MAKE FROM EXTRUSION D2423
- 2) BREAK ALL EDGES 0.000-0.015
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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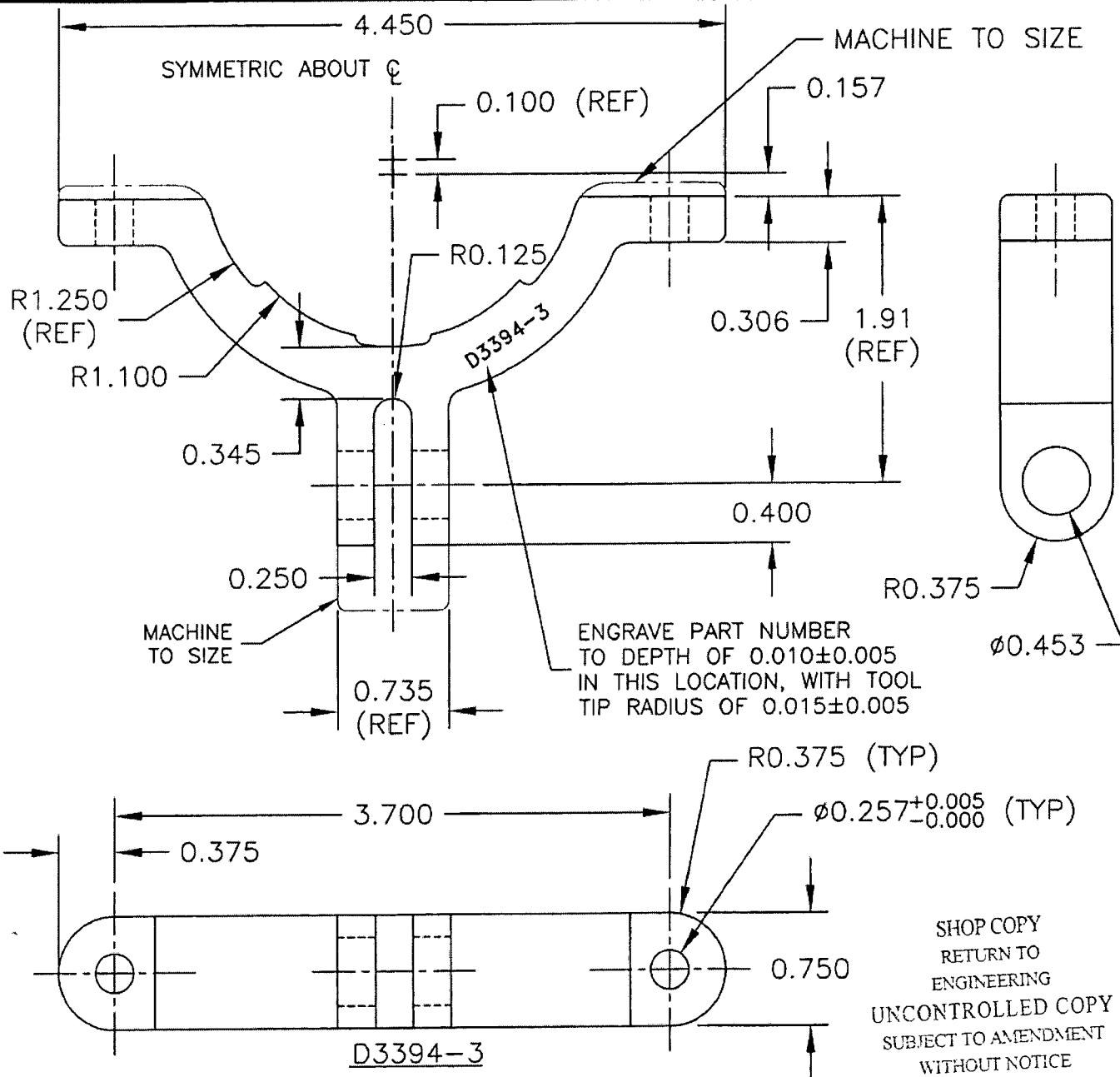
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| | | | | |
|---------|--------------------|----------|--------------------|--|
| DESIGN | PH | DRAWN BY | PH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA |
| CHECKED | <i>[Signature]</i> | APPROVED | <i>[Signature]</i> | DRAWING NO. D3394 |
| DATE | 05.02.14 | TITLE | LUG | REV. A SHEET 3 OF 3 |
| | | | | SCALE 1:1 |

**D3394-3 NOTES**

- 1) MAKE FROM EXTRUSION D2423
- 2) BREAK ALL EDGES 0.000-0.015
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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